

CLAIMS

1. Die set for forming cartridge cases (1;101) from a sheet, comprising at least three support elements, respectively an upper element (1100), middle element (1200) and bottom element (1300), characterized in that they are connected together in the longitudinal direction by guide columns (1001) along which said upper support (1100) and bottom support (1300) are actuated displaceably relative to each other in predefined working sequences, in that said upper support element (1100) and bottom support element (1300) are movable relative to the fixed middle element (1200) and in that said middle support element (1200) comprises means (1230) for shearing and means (1240) for forming the case (1;100) able to co-operate with corresponding locating means (1330,1340) associated with said bottom support element (1300).
2. Die set according to Claim 1, characterized in that said means (1230) for shearing and means (1240) for forming the case (1;101) comprise a sleeve (1210) extending in the axial direction and constrained to the middle support element by means of internally threaded elements (1211) suitable for mating with the threaded opposite ends (1210a) of the said sleeve.
3. Die set according to Claim 1, characterized in that said means (1230) for shearing and means (1240) for forming the case (1;101) comprise a blanking punch (1230) arranged inside the sleeve (1210) and coaxially arranged so as to extend outside the side of the middle support element (1200) directed towards the bottom element (1300).
4. Die set according to Claim 3, characterized in that the opposite ends of said blanking punch (1230)

are respectively locked inside said sleeve (1210) and axially project towards the outside of the middle support element.

5 5. Die set according to Claim 2, characterized in that said sleeve (1210) has, arranged coaxially inside it, a containing bush (1220) housing internally an adjustable-load spring (1221), the opposite ends of which bear respectively against a closing element
10 10 (1222) and against the said blanking punch (1230).

6. Die set according to Claim 1, characterized in that said forming means comprise a drawing punch (1240) integral with one end of a rod (1241), the opposite end of which is integrally fixed to the upper support element (1100) with the arrangement of a spring (1243) in between.
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7. Die set according to Claim 6, characterized in that said rod (1241) has passing through it axially a duct (1242) for supplying air to the drawing punch (1240).
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8. Die according to Claim 6, characterized in that said rod (1241) passes coaxially through the closing element (1222) and the spring (1221).
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9. Die set according to Claim 6, characterized in that the end part of the drawing punch (1240) directed towards the top part of the die set has a seat (1245a) able to contain a shearing ring (1245).
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10. Die set according to Claim 6, characterized in that the end part of the blanking punch (1240) has an axial seat (1241) able to contain the boring tip (1353).
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11. Die set according to Claim 1, characterized in that the bottom support element (1300) has, inserted inside it, a shearing die (1330).

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12. Die set according to Claim 11, characterized in that the bottom support element (1300) has, inserted inside it, a drawing die (1340) coaxial with said shearing die (1330).

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13. Die set according to Claim 1, characterized in that the bottom support element (1300) has, inserted inside it, an extractor (1360).

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14. Die set according to Claim 1, characterized in that the bottom support element (1300) has, inserted inside it, a boring punch (1350).

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15. Die set according to Claim 11, characterized in that the shearing die (1330) is axially fixed to the bottom support element (1300).

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16. Die set according to Claim 12, characterized in that the drawing die (1340) is axially fixed to the bottom support element (1300).

17. Die set according to Claim 14, characterized in that the boring punch (1350) is axially fixed to the bottom support element (1300).

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18. Die set according to Claim 13, characterized in that said extractor (1360) comprises a cup member (1361) movable axially against the thrusting action of spring means (1362).

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19. Die set according to Claim 17, characterized in

that said cup member (1361) has a coaxial opening (1361a) able to allow means (1350) for boring the case (1;101) to pass through.

5 20. Die set according to Claim 14, characterized in
that said boring punch (1350) comprises a tip (1353)
integral with the top end of a column (1352).

10 21. Die set according to Claim 21, characterized in
that the boring punch (1352) comprises an annular
surface (1370) arranged coaxially with the said punch
and at a suitable axial distance from the boring tip
(1353), the said annular surface being provided with
reliefs (1371,1372) for engraving the bottom of the
15 case (1;101).

20 22. Die set according to Claim 21, characterized in
that the forming punch (1240) envisages a free surface
for making contact with the disk (10), associated with
a surface (1270) on which recesses (1271,1272)
corresponding to the reliefs (1371,1372) on the
annular engraving surface (1370) are formed.

25 23. Die set according to Claim 1, characterized in
that it comprises an element (1310) for axially closing
the seat housing the said boring means (1350).

30 24. Die set according to Claim 1, characterized in
that said case (101) has a surface graphically pre-
printed in one or more colours.

35 25. Machine for forming a case (1;101) from a sheet,
comprising a die set comprising at least three support
elements, respectively upper element (1100), middle
element (1200) and bottom element (1300), characterized
in that they are connected together in the longitudinal

direction by guide columns (1001) and/or by sliding surfaces along which said upper support element (1100), middle support element (1200) and bottom support element (1300) are actuated displaceably relative to 5 each other in predefined working sequences, in that said middle support element (1200) is fixed and in that said middle support element (1200) comprises shearing means (1230) and drawing punch (1240) for forming the case (1;101), able to co-operate with corresponding 10 means (1330,1340) associated with said bottom support element (1300).

26. Machine according to Claim 25, characterized in that it is a press.

15 27. Machine according to Claim 25, characterized in that said shearing means (1230) and means (1240) for forming the case (1;101) comprise a sleeve (1210) extending in the axial direction and constrained to the 20 middle support element by means of internally threaded elements (1211) suitable for mating with the threaded opposite ends (1210a) of the said sleeve.

25 28. Machine according to Claim 25, characterized in that said means (1230) for shearing and means (1240) for forming the case (1;101) comprise a blanking punch (1230) arranged inside the sleeve (1210) and coaxially arranged so as to extend outside the side of the middle support element (1200) directed towards the bottom 30 element (1300).

29. Machine according to Claim 27, characterized in that the opposite ends of said blanking punch (1230) are respectively locked inside said sleeve (1210) and 35 axially project towards the outside of the middle support element.

30. Machine according to Claim 26, characterized in
that said sleeve (1210) has, arranged coaxially inside
it, a containing bush (1220) housing internally an
5 spring (1221), the opposite ends of which bear
respectively against a closing element (1222) and
against said blanking punch (1230).

31. Machine according to Claim 25, characterized in
10 that said forming means comprise a drawing punch (1240)
integral with one end of a rod (1241), the opposite end
of which is integrally joined to the upper support
element (1100) with the arrangement of a spring (1243)
in between.

15 32. Machine according to Claim 30, characterized in
that said rod (1241) has passing through it axially a
duct (1242) for supplying air to the drawing punch
(1240).

20 33. Machine according to Claim 30, characterized in
that said rod (1241) passes coaxially through the
closing element (1222) and the spring (1221).

25 34. Machine according to Claim 30, characterized in
that the end part of the drawing punch (1240) directed
towards the inside of the middle support element (1200)
has a seat (1245a) able to contain a shearing ring
(1245).

30 35. Machine according to Claim 30, characterized in
that the end part of the drawing punch (1240) directed
towards the upper support of the die set has a seat
(1241) able to contain the tip (1353) of the boring
35 punch (1352).

36. Machine according to Claim 25, characterized in that the bottom support element (1300) has, inserted inside it, a shearing die (1330).

5 37. Machine according to Claim 25, characterized in that the bottom support element (1300) has, inserted inside it, a drawing die (1340) coaxial with said shearing die (1330).

10 38. Machine according to Claim 25, characterized in that the bottom support element (1300) has, inserted inside it, an extractor.

15 39. Machine according to Claim 25, characterized in that the bottom support element (1300) has, inserted inside it, a boring punch (1350).

20 40. Machine according to Claim 35, characterized in that the shearing die (1330) is axially fixed to the bottom support element (1300).

41. Machine according to Claim 36, characterized in that the drawing die (1340) is axially fixed to the bottom support element (1300).

25 42. Machine according to Claim 39, characterized in that the boring punch (1350) is axially fixed to the bottom support element (1300).

30 43. Machine according to Claim 37, characterized in that said extractor (1360) is formed by a cup member (1361) movable axially against the thrusting action of spring means (1362).

35 44. Machine according to Claim 42, characterized in that said cup member (1361) has an opening (1361a)

allowing means for boring the bottom of the case (1;101) to pass through.

5 45. Machine according to Claim 38, characterized in that said boring punch (1350) comprises a tip (1353) integral with the top end of a column (1352).

10 46. Machine according to Claim 38, characterized in that said boring punch (1352) comprises an annular surface (1370) arranged coaxially with the said punch and at a suitable axial distance from the boring tip (1353), the said annular surface being provided with reliefs (1371,1372) for engraving the bottom of the case (1;101).

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20 47. Machine according to Claim 46, characterized in that the forming punch (1240) envisages a free surface associated with a surface (1270) on which recesses (1271,1272) corresponding to reliefs on the annular engraving surface are formed.

48. Machine according to Claim 25, characterized in that it comprises an element (1310) for axially closing the seat housing the said boring means (1350).

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49. Machine according to Claim 25, characterized in that said case (101) has a pre-printed surface.

30 50. Method for forming a cartridge case (1; 101) from a sheet, characterized in that it comprises the following steps:

e) supplying a sheet of metal (10) to a forming machine (20);

f) forming sharing and boring the case (1;101) in a single stage by three coaxial movements of a

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forming die set;
g) extraction of the formed and bored case (1;101).

5 51. Method according to Claim 50, characterized in
that said metal sheet (10) is cut to a predefined size.

52. Method according to Claim 50, characterized in
that said forming operation is a drawing operation.

10 53. Method according to Claim 50, characterized in
that said forming and boring operations are performed.

15 54. Method according to Claim 50, characterized in
that the case obtained (1;101) has a substantially
constant thickness along the side surface and bottom.

55. Method according to Claim 50, characterized in
that it comprises a further step for widening the
bottom (1b) of the case (1;101).

20 56. Method according to Claim 50, characterized in
that it comprises a further step for printing the
bottom (1b) and/or the external side surface of the
case (1;101).

25 57. Method according to Claim 56, characterized in
that said further printing step is performed in-line.

30 58. Method according to Claim 56, characterized in
that said further printing step consists in
tampography, serigraphy or printing with an electronic
pen.

35 59. Method according to Claim 50, characterized in
that the material used for forming the case is steel.

5 60. Method according to Claim 59, characterized in
that the said material is preferably steel lined
electrolytically and/or suitable for combination with a
film of metal such as brass, stainless steel, zinc,
aluminium, titanium, copper and/or plastic.

10 61. Method according to Claim 59, characterized in
that said material is preferably steel lined with tin.

15 62. Method according to Claim 59, characterized in
that the case (1;101) comprises a further step for
painting the cut edges.

20 63. Method according to Claim 61, characterized in
that said painting is performed by means of
electrophoresis.

25 64. Method according to Claim 50, characterized in
that said material is preferably aluminium and alloys
thereof.

30 65. Method according to Claim 50, characterized in
that it comprises the following steps) downstream of
the step for cutting the sheet (10) and upstream of the
step for forming the case (1;101):

- b) lithographic printing of a surface of the sheet (10);
- c) varnishing the printed sheet (10) with a layer of protective varnish;
- d) polymerization of the print and the varnish.

35 66. Method according to Claim 65, characterized in
that the protective varnish applied to the print is of
the polyester, epoxy ureic, polyurethane, epoxide type

containing zirconium or water.

67. Method according to Claim 65, characterized in
that polymerization of the print and the varnish is
5 performed using hot air.

68. Method according to Claim 67, characterized in
that the temperature of the hot-air oven is kept
between 180° and 220°C.

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69. Method according to Claim 68, characterized in
that the temperature of the hot-air oven is preferably
kept between 195° and 205°C.

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70. Method according to Claim 65, characterized in
that polymerization of the print and the varnish is
performed using UV rays.

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71. Method according to Claim 50 or 65, characterized
in that it envisages a step involving engraving of the
bottom of the case during boring thereof.